

Page 1

January-31-13 9:54:33 AM Item ID: D2933-2 Accept *N900040100* Setup Start Revision ID: Saddle RH In. 206 Item Name: **Start Date:** 1/31/13 Start Qty: 2.00 Cust Item ID: Required Date: 2/06/13 Req'd Qty: 2.00 **Customer:** Reference: Run Process Plan: MLJ Date: 13-61-31 Tooling: **Approvals:** Date: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID **Description Run Hours** Code **Qty** Oty Number Stamp Draw Nbr **Revision Nbr** D2933 Rev C 100 0.00 and 13/02/04 2 9 HAAS CNC VERTICAL MACHINING #1 *100* HAAS 1 0.00 Memo HAAS CNC westical machine #1 Program part number and batch number. I-Inspect part number and batch number are programmed correctly.2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per 110 0.00 and 13/02/04 2 19 CONVENTIONAL MILLING MACHINE *110* Mill Conv 0.00 Memo Conventional Milling Machine Machine Keyway and inspect per attached dimension sheet 120 and 13/02/04 QC1- Inspect dimensions to dimension sheet 0.00 *120* OC 0.00 Memo Quality Control

											DQA:	Date:	
NCR: Y	'es	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPDAT	E	-		
											QA Closed:	Date:	
Nork Orde	ır.					DISPOSITION			А	GAINST DEF	PARTMENT/	PROCESS	
WOIK OIGE	:1.					Rework	٦		Skid-tube Cr	osstube		Water Jet	Engineering
Part N	10.					Scrap	1. 1		—	mall Fab	Proc	d. Eng. Coor.	Quality
	•					Use-as-is]	Therm	noforming F	inishing	Rec/Stor	e/Packaging	Other
NCR N	lo.					Work Order Update			Large Fab Cor	mposite 🔙		Supplier] []
		The state of the s	r	1			<u> </u>			· · ·	C: 0		
Root		Data	Cham			iption of work order update or Non-conformance		nitial iief Eng	Action Description	_	Sign & Date	Verification	QC Inspector
Cause	_	Date	Step	Qty	<u> </u>	or Non-conformance	Cn	nei Eng	Description	<u> </u>	Date	vernication	QC IIIspector
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						<u> </u>	FAUL	T CATE	GORY				
Landi	ng (Gear			_	General		1			1	_	_
		Bending				Bend	_	Grain		 	Ovalized		Pressure/Forced
		Centre No	t Concer	ntric to	o/s	BOM/Route	<u> </u>	Hardwa		ļ	Over/Under		Temperature/Cure
		Cracks			<u> </u>	Broken/Damaged	_	4 `	on Incomplete		Part Incorred	<u> </u>	Weld
		Crushed/0	Crimped.		<u> </u>	Burrs	_	4	ions Incomplete/Unclea	ar	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs			-	Contamination	-	Mainte		<u> </u>	Part Moved		
		Heat Trea			<u> </u>	Countersink	-	Mislabe		-	Positioned V		7045
		Inspection		Tube	<u> </u>	Cut Too Short	-	Misread	1	L	Power Loss/	Surge	Other
Ripples in Bend Drill Holes Torque Waves in Extrusion Drawing							\vdash	Offset	Zalikuski au				
	_				n -	Drawing	\vdash	4	Calibration				
i		Turning Se	•		-	Finish Folio	\vdash	4	Sequence				
		Wave/Twi	ist in Tub	e e		[FOIIO	- 1	JUutside	Dimensions				

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January-31-13 9:54:33 AM

Item ID: D2933-2

Revision ID:
Item Name: Saddle RH In. 206

Start Date: 1/31/13 Start Pate: 2/06/13 Re

Start Qty: 2.00 *2
Reg'd Qty: 2.00 *2

N900040100

Cust Item ID: Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date: SPC (Y/N): Date: Stop *NR2*

							•	171	R/"
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00					- •		/DA-DAD
<u>*130*</u>			13-2-4			7	4		1 2/3
QC Ouglity Control	Мето	0.00				0	- P		

140

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

Accept

140
HandFinish
Hand Finishing

Memo

2 \$ DY B-2-4.

Setup Start

NCR:	Yes	/ No				WORK ORDER NON-O	COL	NFORN	/ANCE / UPC	DATE			
											QA Closed:	Date:	
Work Ord	or:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIK OIG	٠					Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part I	Vo.					Scrap	1 1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•					Use-as-is	1		noforming	Finishing	4	re/Packaging	Other
NCR I	No.			····		Work Order Update]	i	Large Fab	Composite		Supplier	
Root					Descri	ption of work order update	Π	Initial	Acti	ion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data									I				
Equip/Tooling									į				
Operator											'		
Material	Ш											i i	
Setup	Ш												
Other								-					
Process													
Supplier													
Training	Ш		į										
Unapproved													
						F	AUL	T CATE	GORY				
Landi	ng G	Gear				General	_	-			7		7
	Ш	Bending				Bend		Grain			Ovalized		Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Ш	Cracks				Broken/Damaged		Inspecti	ion Incomplete	ļ	Part Incorre	ct	Weld
		Crushed/	Crimped.			Burrs	L	Instruct	ions Incomplete/U	Jnclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		
		Heat Trea	it			Countersink		Mislabe	·led		Positioned V	Wrong	_
		Inspectio	n Strip in	Tube		Cut Too Short	L	Misread	i		Power Loss/	'Surge	Other
		Ripples in	Bend			Drill Holes		Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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Quality Control

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January-31-13 9:54:33 AM Item ID: D2933-2 Accept *N900040100* Setup Start **Revision ID:** Item Name: Saddle RH In. 206 **Start Date:** 1/31/13 Start Oty: 2.00 **Cust Item ID:** Required Date: 2/06/13 Rea'd Oty: 2.00 Customer: Reference: Run Process Plan: Approvals: Date: **Tooling:** Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Reject Accept Reject Insp. Work Center ID Description **Run Hours** Qty Number Stamp Code Qty 145 Spray Painting per QSI005 4.2 0.00 *145* SprayPaint 0.00 Memo **Spray Painting** PRIME B 117319 START: 6:30 FINISH: 7:00 DELFLEET BLUE B 121722 DELFLEET CLEAR B 118093 START: 9:00 FINISH: 10:30 155 QC14- Inspect Spray Paint 0.00 QC 0.00 Memo

NCR: Y	Yes	/ No				WORK ORDER NON-C	O	NFORN	MANCE / UP		DQA:	Date:	
				-			I				QA Closed:	Date:	
Work Orde	or.					DISPOSITION		AGAINST DEPARTMENT/PROCESS					
	_					Rework				_	Water Jet	Engineering	
Part N	۱o. <u>-</u>					Scrap	∤ 		Machining	Small Fab		d. Eng. Coor.	Quality
NCR N	No					Use-as-is Work Order Update			noforming Large Fab	Finishing Composite	Rec/Stor	e/Packaging Supplier	Other
Root					Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup													
Other	Ц		İ										
Process													
Supplier	Ш												
Training	Ш												,
Unapproved			<u> </u>				<u> </u>						
						F	AUL	T CATE	GORY				
Landi	ng G	ear			<u></u>	General		1		F	٦		1
		Bending				Bend		Grain			Ovalized		Pressure/Forced

L	Juenung	Швена		Ovanized	
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped	Burrs	Instructions Incomplete/Unclea	ar Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination	Maintenarice	Part Moved	
	Heat Treat	Countersink	Mislabeled	Positioned Wrong	_
	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes	Offset		
[Torque Waves in Extrusion	Drawing	Out of Calibration		
	Turning Sequence	Finish	Out of Sequence		
ſ	Wave/Twist in Tube	Folio	Outside Dimensions		

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96708

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January-31-13 9:54:33 AM Item ID: D2933-2 Accept *N900040100* Setup Start Revision ID: Saddle RH In. 206 Item Name: **Start Date:** 1/31/13 Start Otv: 2.00 **Cust Item ID:** Required Date: 2/06/13 **Rea'd Otv:** 2.00 **Customer:** Reference: Run Approvals: Process Plan: Date: Tooling: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool# Reject Plan Accept Reject Work Center ID Description Run Hours Code Qty Number Stamp Otv 170 Identify as per dwg & Stock Location: 0.00 *170* 5+422 Packaging 0.00 Memo Packaging 180 QC21- Final Inspection - Work Order Release 0.00 MB 02-07 *180* QC 0.00 Memo Quality Control

NCD.	Voc	1	Ma
NCR:	Yes	/	No

DQA: _____ Date: ____

NCR: Y	'es / No				WORK ORDER NON-	CONFO	KIVI/ANCE / U	PUAIE	QA Closed:	Date	<u>.</u>
Work Orde	ır.				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap		Skid-tube Machining	Crosstube Small Fab	Water Jet Prod. Eng. Coor.		Engineering Quality
NCR No.					Use-as-is Work Order Update	The	ermoforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root					ption of work order update	Initia	Į.	Action	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief E	ng De:	scription	Date	Verification	QC Inspector
Doc/Data											
quip/Tooling											
Operator	_						ŀ				
Material											
Setup	_					1	1				
Other						-					
Process Supplier											
Training		1									
Unapproved	-										
	<u> </u>		l		F	AULT CA	TEGORY		<u> </u>		
Landir	ng Gear				General	٠					
	Bending				Bend	Grai	n		Ovalized		Pressure/Forced
	Centre No	ot Concei	ntric to (o/s	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Insp	ection Incomplete		Part Incorre	ct [Weld
[Crushed/	Crimped.			Burrs	Instr	uctions Incomplet	e/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mai	ntenarice		Part Moved		
	Heat Trea	at			Countersink	Misl	abeled		Positioned \	N rong	
	Inspectio	n Strip in	Tube		Cut Too Short	Misr	ead		Power Loss,	'Surge	Other
[Ripples in	n Bend			Drill Holes	Offs	et				
[Torque W	Vaves in E	Extrusion		Drawing	—	of Calibration				***
	Turning S	•			Finish		of Sequence				
	Wave/Tw	ist in Tul	oe		Folio	Outs	ide Dimensions				

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Picklist Print

January-31-13 9:54:38 AM

Work Order ID: 96708

96708

Parent Item:

D2933-2

D2933-2

Parent Item Name: Saddle RH In. 206

Start Date: 1/31/13

Required Date: 2/06/13

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP: B00.06.26New DWG rev (mpp 2069)EC IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	83.0000	1	2			
D6101-00)1								**	<i>-</i>	PO	13/01/	31

Location	Loc Qty	Loc Code	
MAT040	33		
91236	33		2
MAT042	50		
94445	50		

NCR:	Yes	/	No

DQA:

Date: ___

NCR: Ye	es / No				WORK ORDER NON-C	CONFOR	MANCE / UF		QA Closed:	Date:	
		<u></u>			T					7	
Work Orde	r:				DISPOSITION	İ		AGAINST DE	PARTMENT	/PROCESS	
				····	Rework]	Skid-tube	Crosstube	·	Water Jet	Engineering
Part N	0.				Scrap]	Machining	Small Fab	1	d. Eng. Coor.	Quality
	•				Use-as-is	Ther	moforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	0				Work Order Update]	Large Fab	Composite	j	Supplier]
Root				Descr	iption of work order update	Initial	A	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Des	cription	Date	Verification	QC Inspector
Doc/Data											
quip/Tooling										·	
Operator	_		•								
Material	_					Ì	•				
Setup	_							•			
Other	_										
Process	_	1	·								
Supplier	_	ŀ									
Training					•	}				,	
Unapproved		.l	Ĺ								
						AULT CAT	EGORY				
Landin F	_				General	Пс:		_	Ovalized	Ė	Pressure/Forced
-	Bending			_ <u> </u>	Bend	Grain		<u> </u>	4		Temperature/Cure
-	Centre No	ot Conce	ntric to	^{0/S} -	BOM/Route	Hardv		<u> </u>	Over/Under		Weld
-	Cracks	<i>'</i>		-	Broken/Damaged	⊢	ction Incomplete	///	-∤		Wrong Stock Pulled
-	Crushed/	Crimpea		-	Burrs		ctions Incomplete tenance	Unclear	Part Lost/M Part Moved		Twitolik stock railed
-	Cuffs			-	Contamination	 		` -	-₹		
-	Heat Trea		T I	 	Countersink	Misla			Positioned \	F	Other
-	Inspectio		rube	-	Cut Too Short	Misre			Power Loss,	Surge	Tomer
-	Ripples in			<u> </u>	Drill Holes	Offset					
-	Torque W			n	Drawing	—	f Calibration				
-	Turning S				Finish	⊢	f Sequence				
. 1	Wave/Tw	vist in Tul	oe e	1	Folio	Outsi	de Dimensions				

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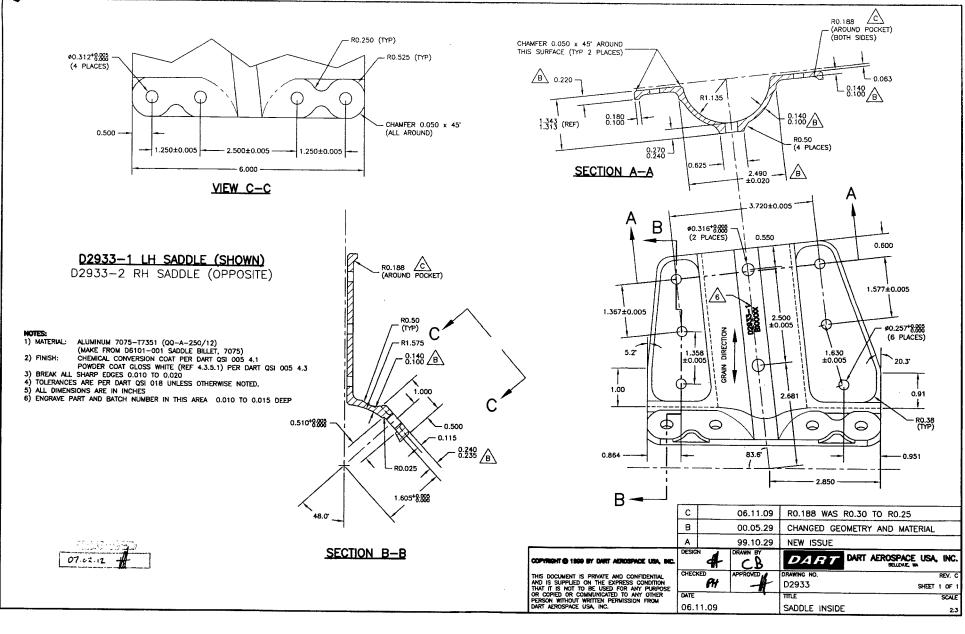
DART AEROSPACE LTD	Work Order:	96708
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	Ву	Date
Α	0.100	0.140		.109	.107				
В	0.100	0.140		.108	.107				
С	0.100	0.140		.110	(11)				<u></u>
D	0.210	0.230		.225	.226				
E	1.245	1.255		1,250	1.250				
F	1.245	1.255		1.250	1.250				
G	2.495	2.505		2.500	2.50D				
Н	0.510	0.515		.511	. 571				
	1.572	1.582		1.579	1.579				
J	2.495	2.505		2.500	2.500				
K	0.257	0.262		.258	.258				
L	0.312	0.317		.3/3	.3/3				
М	0.235	0.240		239	.239				
N	0.100	0.140		122	(122				
0	0.540	0.560		548	.549				
Р	0.490	0.510		502	.500		, <u>.</u>		
Q	3.715	3.725		3.720	3.720				
R	2.470	2.510		2.490	2.490				
S	0.240	0.270		.254	.254				
Т	0.100	0.180		137	.140				
Ū	1.625	1.635		1.630	1.630				
V	1.362	1.372		1.368	1.360				
W	0.316	0.321		3//2	.316				
X	1.125	1.145		1.136	1.13/				·w.
Υ	1.565	1.585	DT8695 A/B	1.573	1.573				
Z	0.178	0.198		.188	. 188				
AA	-		ANTI-	, 00	-100				
AB									
AC									
AD									
AE									
AF									
AG		-						 -	· · · · · · · · · · · · · · · · · · ·
AH								+ - +	
	Acc	ept/Reje	ct				······································		

	,		
Measured by:	corre	Audited by	\$ W (V)
Date:	13/02/04	Date: /	3-2-4

	Approved
RF	
KJ/RF	- 1
KJ/JLM cx	Gul!
	1.0



SHOP COPY
RETURN TO
FNGINETRING
ENCONTROLLED COPY
BY CT TO AMENDMENT
WITHOUT NOTICE
VORK ORDER
13-01-31